

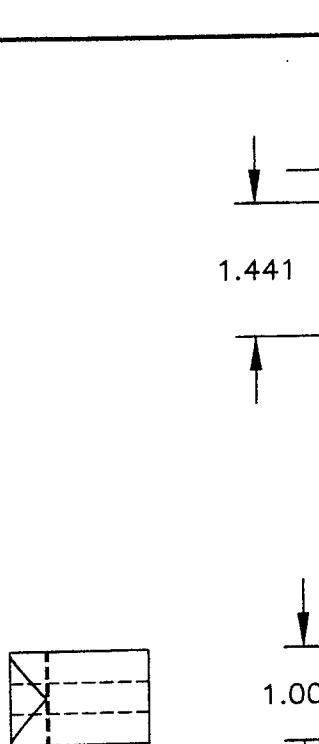
43

DART AEROSPACE LTD	Work Order:	21560
Description: Bracket	Part Number:	D3228-041/-042
		D3228-043/-044
Dwg: D3228 Rev. A	Qty:	4 Kits
D3228-041/-042 replaces Helitech P/N: 358-011-001/-002		Page 1 of 2
D3228-043/-044 replaces Helitech P/N: 358-012-001/-002		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller <b>Note: Each Kwik Float Kit consists of (2) D3228-041; (2) D3228-042; (2) D3228-043; (2) D3228-044</b>	JF	04.09.23	4
2	MV	Cut (8) blanks: 1.250" x 1.500" x 6.975" long (+/- 0.030) per Kit. Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-250/11 (M6061T6B1.500x01.250) <b>Identify for D3228-1/2/3/4</b> Batch: M7703	EP	04/12/17	4
3	MV	Machine (2) D3228-1 per Kit as per Folio FA367 & Dwg D3228 <b>Identify as D3228-1</b>			
4	QC2	Inspect parts as they come off the CNC machine			
5	MV	Deburr and break all sharp edges 0.005"-0.010"			
6	QC8	Second inspection			
7	MV	Machine (2) D3228-2 per Kit as per Folio FA367 & Dwg D3228 <b>Identify as D3228-2</b>			
8	QC2	Inspect parts as they come off the CNC machine			
9	MV	Deburr and break all sharp edges 0.005"-0.010"			
10	QC8	Second inspection.			
11	MV	Machine (2) D3228-3 per Kit as per Folio FA367 & Dwg D3228 <b>Identify as D3228-3</b>			
12	QC2	Inspect parts as they come off the CNC machine			
13	MV	Deburr and break all sharp edges 0.005"-0.010"			
14	QC8	Second inspection			
15	MV	Machine (2) D3228-4 per Kit as per Folio FA367 & Dwg D3228 <b>Identify as D3228-4</b>	EP	04/12/17	4
16	QC2	Inspect parts as they come off the CNC machine	EP	04/12/17	4
17	MV	Deburr and break all sharp edges 0.005"-0.010"	EP	04/12/17	4
18	QC8	Second inspection	EP	04/12/17	4
19	FP	Chemical Conversion Coat as per QSI 005 4.1 D3228-1/-2/-3/-4	ML	05/01/17	4
20	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 D3228-1/-2/-3/-4	ML	05/01/17	4
21	QC3	Inspect Powder Coat	ML	05/01/17	4
22	GA	Fabricate (4) D3228-5 (make from D2397) per Kit. <b>Pick:</b> Part Number D2397      Description Rubber Cushion      Batch _____ <b>Identify as D3228-5</b>			

RELEASED

03.11.27



RELEASED

03.12.05

D3228-041/-042 BRACKET

- 1) MATERIAL:  
D3228-1/-2: 60  
D3228-5: MAKE F
- 2) FINISH: CHEMICAL CONVER  
POWDER COAT WH
- 3) BREAK ALL SHARP EDGES
- 4) ALL DIMENSIONS ARE IN II
- 5) TOLERANCES ARE PER DA
- 6) ENGRAVE P/N AND LETTER
- 7) INSTALL D3228-5 PACKER

DART AEROSPACE LTD		Work Order:	21560
Description: Bracket		Part Number:	D3228-041/-042
			D3228-043/-044
Dwg: D3228 Rev. A		Qty:	4 Kits
D3228-041/-042 replaces Helitech P/N: 358-011-001/-002			Page 2 of 2
D3228-043/-044 replaces Helitech P/N: 358-012-001/-002			

Step	Location	Procedure	By	Date	Qty																
23	GA	Fabricate (4) D3228-7 (make from D2397) per Kit. <b>Pick:</b> <table border="1"><tr><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>D2397</td><td>Rubber Cushion</td><td>B16515</td></tr></table> <b>Identify as D3228-7</b>	Part Number	Description	Batch	D2397	Rubber Cushion	B16515		205-01-13	4										
Part Number	Description	Batch																			
D2397	Rubber Cushion	B16515																			
24	GA	Assemble (2) D3228-041 as per Dwg D3228. (Note: D3228-1 & -5 are on BOM as material from Step 2 & 22) <table border="1"><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>2</td><td>D3228-1</td><td>Bracket</td><td></td></tr><tr><td>2</td><td>D3228-5</td><td>Packer</td><td></td></tr><tr><td>A/R</td><td></td><td>Contact Cement</td><td></td></tr></table> <b>Identify as D3228-041</b>	Qty	Part Number	Description	Batch	2	D3228-1	Bracket		2	D3228-5	Packer		A/R		Contact Cement				
Qty	Part Number	Description	Batch																		
2	D3228-1	Bracket																			
2	D3228-5	Packer																			
A/R		Contact Cement																			
25	GA	Assemble (2) D3228-042 as per Dwg D3228. (Note: D3228-2 & -5 are on BOM as material from Step 2 & 22) <table border="1"><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>2</td><td>D3228-2</td><td>Bracket</td><td></td></tr><tr><td>2</td><td>D3228-5</td><td>Packer</td><td></td></tr><tr><td>A/R</td><td></td><td>Contact Cement</td><td></td></tr></table> <b>Identify as D3228-042</b>	Qty	Part Number	Description	Batch	2	D3228-2	Bracket		2	D3228-5	Packer		A/R		Contact Cement				
Qty	Part Number	Description	Batch																		
2	D3228-2	Bracket																			
2	D3228-5	Packer																			
A/R		Contact Cement																			
26	GA	Assemble (2) D3228-043 as per Dwg D3228. (Note: D3228-3 & -7 are on BOM as material from Step 2 & 23) <table border="1"><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>2</td><td>D3228-3</td><td>Bracket</td><td></td></tr><tr><td>2</td><td>D3228-7</td><td>Packer</td><td></td></tr><tr><td>A/R</td><td></td><td>Contact Cement</td><td></td></tr></table> <b>Identify as D3228-043</b>	Qty	Part Number	Description	Batch	2	D3228-3	Bracket		2	D3228-7	Packer		A/R		Contact Cement				
Qty	Part Number	Description	Batch																		
2	D3228-3	Bracket																			
2	D3228-7	Packer																			
A/R		Contact Cement																			
27	GA	Assemble (2) D3228-044 as per Dwg D3228. (Note: D3228-4 & -7 are on BOM as material from Step 2 & 23) <table border="1"><tr><td>Qty</td><td>Part Number</td><td>Description</td><td>Batch</td></tr><tr><td>2</td><td>D3228-4</td><td>Bracket</td><td>B21560</td></tr><tr><td>2</td><td>D3228-7</td><td>Packer</td><td>B16515</td></tr><tr><td>A/R</td><td></td><td>Contact Cement</td><td>M11854</td></tr></table> <b>Identify as D3228-044</b>	Qty	Part Number	Description	Batch	2	D3228-4	Bracket	B21560	2	D3228-7	Packer	B16515	A/R		Contact Cement	M11854		05-01-13	4
Qty	Part Number	Description	Batch																		
2	D3228-4	Bracket	B21560																		
2	D3228-7	Packer	B16515																		
A/R		Contact Cement	M11854																		
28	QC5	Inspect work to Step 27		05-01-17	4																
29	ST	Identify and Stock in Kwik Float Cell D3228-041 Qty: 4 D3228-042 Qty: 4 D3228-043 Qty: 4 D3228-044 Qty: 4		05-01-17	4																
30	AC	Parts to Stock and Prorate cost to parts per Step 29 Cost / part 47.45		05-01-18	4																
31	DC	Close W/O 47.45 Inspect Level 21		05.01.25	4																

Rev	Date	Change	Revised By	Approved
A	03.11.11	New issue	KJ/JLM/DS	

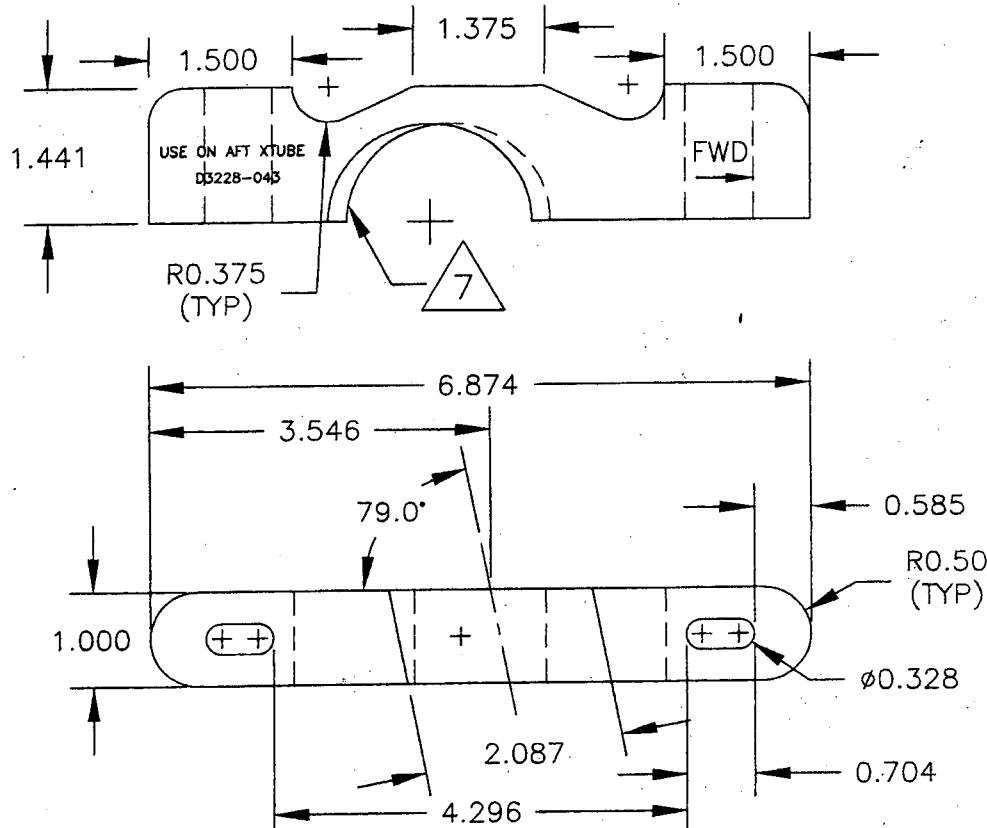
RELEASED

03.11.27

COPY/GS  
CUT

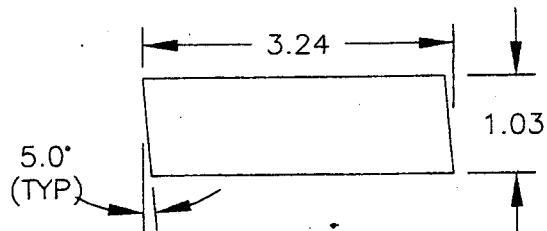
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE	03.10.28	D3228	SHEET 2 OF 2

1:2



D3228-043 BRACKET (SHOWN. REPLACES HELITECH P/N 358-012-001)  
D3228-044 BRACKET (OPPOSITE. REPLACES HELITECH P/N 358-012-002)

RELEASED

03.12.05 *[Signature]*

D3228-7 PACKER  
**SHOP COPY**

RETURN TO  
ENGINEERING

**UNCONTROLLED COPY**  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE

**WORK ORDER**NO. *21560*

D3228-043/-044 BRACKET (D3228-4/-3 BRACKET, D3228-7 PACKER)

## 1) MATERIAL:

D3228-3/-4: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-250/11)  
 D3228-7: MAKE FROM D2397

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

## 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

## 4) ALL DIMENSIONS ARE IN INCHES

## 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

## 6) ENGRAVE P/N AND LETTERING AS SHOWN

## 7) INSTALL D3228-7 PACKER ON THIS SURFACE AFTER PAINT USING CONTACT CEMENT

Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Sep 22, 2004  
03:57 pm

Work Order No	:	0021563	Department Code:
Project Name	:	D3228-044	Burden Flags : NNNNNNN
Project For	:	WK443	WO Status : Open
Work Order Type	:	Main	Invoice State : Not Invoiced
Main WO Number	:		Invoice Date :
House Part Number	:	D3228-044	Invoice Number :
Description	:	Bracket Assembly	Invoice Amount : 0.00
Manufactured	:	Yes	
Amount Req'd	:	4	
Amount Done	:	0	Order Entry No :
Start Date	:	09-22-04	OE Value : 0.00
Est Finish Date	:	10-23-04	
Act Finish Date	:		Est Margin : 0.000%
Drawings Reqd	:	No	Actual Margin : 0.000%
Ok for Approval	:		
Approval Rec'd	:		\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00

DART AEROSPACE LTD	Work Order:	21560
Description: KWIK FLOAT BRACKET	Part Number:	D3228- <del>000</del> 4
Inspection Dwg: D3228 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	<i>EP</i>	Audited by:	<i>JNL</i>	Prototype Approval:	<i>Q</i>
Date:	04/12/16	Date:	04/12/17	Date:	05/12/17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	